Hjorth Drill Angle Testing Gauge

(Patend allowed)

No. 1.

The simplest, most efficient and economical tool ever devised for testing the accuracy of drills. Few operations in the machine shop are attended with such uncertain and unsatisfactory results as the sharpening and grinding of drills. That the cutting edges have a proper and uniform angle (59°) with the longitudinal axis of the drill, having them of exactly equal length and the lips of the drill well and sufficiently backed off or cleared, are features generally recognized as essential to the performance of a drill, failure to attain which will produce a crooked and irregular hole.

A **correctly** ground drill does **better** and **quicker** work, requires grinding **less** frequently and is not so **easily** broken as when incorrectly ground.

The use of this tool **obviates** the **expensive** and **complicated** mechanisms known as drill grinders, and reduces to a minimum the time consumed in the operation of drill sharpening.

This tool has been pronounced by drill manufacturers and others as one of the most useful time-saving devices in the shop.

No. 2

Three Sizes	No. 1	Capacity up to ½ in. drills	**$1.50** each
	No. 2	Capacity up to 1 in. drills	**$2.00** each
	No. 3	Capacity up to 2 in. drills	**$3.50** each

MANUFACTURED BY

HJORTH LATHE & TOOL COMPANY

Offices:
27 SCHOOL STREET
BOSTON, MASS.

Works:
BEACON STREET
WOBURN, MASS.

FOR SALE BY

OVER

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No. 3

DIRECTIONS

After proper grinding of the heel of the lip, the cutting edges of the drill should be carefully ground, care being exercised not to draw the temper. The drill should then be placed firmly and evenly in the V groove of the handle portion of the tool, raising or lowering the gauge jaw so that the point of the drill becomes central with the point of the V gauge. The cutting edges of the drill should be horizontal with the flat surfaces of the gauge jaw.

The gauge jaws are milled with an angle of 59° and the **cutting edges of both lips of the drill should be parallel with the edges of the V gauge.**

It should always be borne in mind that when one lip of the drill is lower than the other, the strain in drilling comes on the shorter lip of the drill, producing an irregular and larger hole than the diameter of the drill, while increasing the liability of breakage.

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